100163

April-18-13 1:20:53 PM

Item ID: D4030-041 Accept *N900040100* Setup Start Revision ID: Item Name: Long Basket Assembly (350) *1* Start Date: 4/18/13 Start Qty: 1.00 Cust Item ID: Required Date: 5/02/13 Req'd Qty: 1.00 **Customer:** Reference: Run Start Process Plan: MLJ Date: 13-04-18 Tooling: Approvals: Date: Stop Date: _____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. **Work Center ID** Description **Run Hours** Qty Code **Qty** Number Stamp Draw Nbr **Revision Nbr** D4030 C 100 Pick Kit 0.00 *100* Packaging 0.00 Memo Packaging 110 Assemble as per dwg 0.00*110* HandFinish 0.00 Memo Hand Finishing ****Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label **** 120 او QC5- Inspect part completeness to step on W/O *120* Memo Quality Control

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-C	CON	IFORN	MANCE / UPDATE		QA Closed:	Date:	
				. ·			Т					the second secon	
Work Orde	er:					DISPOSITION			AGA	INST DE	PARTMENT	PROCESS	
Work Orac	-					Rework	1		Skid-tube Cross	tube		Water Jet	Engineering
Part N	٧o.					Scrap		l	Machining Smal	l Fab		d. Eng. Coor.	Quality
	-					Use-as-is							Other
NCR No.						Work Order Update]		Large Fab Comp	osite		Supplier	
Root	Ī				Descri	ption of work order update	lr	nitial	Action		Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Chi	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data							İ						
Equip/Tooling													
Operator													
Material													
Setup												,	
Other													
Process .													
Supplier													
Training							-						
Unapproved												<u> </u>	1
							AUL'	T CATE	GORY				
Landi	ng G	Gear				General				_	1	ſ-	
	Ш	Bending				Bend		Grain		_	Ovalized	<u> </u>	Pressure/Forced
	Ш	Centre No	ot Conce	ntric to	O/S	BOM/Route		Hardwa	re	ļ	Over/Under	-	Temperature/Cure
	Ш	Cracks				Broken/Damaged	-	-	on Incomplete		Part Incorre	F	Weld
		Crushed/	Crimped.	-		Burrs	\vdash		ions Incomplete/Unclear	<u> </u>	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs Contamination				1	Mainte		<u> </u>	Part Moved			
		Heat Trea	it			Countersink	Ш	Mislabe	led	<u> </u>	Positioned V		_
		Inspectio	n Strip in	Tube		Cut Too Short	Ш	Misread	· .		Power Loss/	'Surge	Other
i	Ripples in Bend Drill Holes					Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

4pril-18-13 1:2		JU [63]		*100	1163*						Page 2
Item ID: Revision ID: Item Name:	D4030-041 Long Basket	Assembly (350)		Accept	*N900	040	100) *	Setup Star Stop	171	S1* S2*
Start Date: Required Date: Reference:	4/18/13 5/02/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:				IN	,)
Approvals:	Process Plan:				Date: Date:			F	Run Star Stop	" \	R1* R2*
Sequence ID/ Work Center II 130 *120* Packaging Packaging	D	Operation Description Identify as per dwg & Sto	ock Location:	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC		QC21- Final Inspection -	Work Order Release	0.00		·			13/5	1/28	H

Quality Control

MF 13-5-57

								DQA:	Date:	
NCR: Ye	es / No			WORK ORDER NON-	CONFORM	MANCE / UF		QA Closed:	Date:	
Work Order	••			DISPOSITION			AGAINST DEI	PARTMENT	/PROCESS	
Work Order	•			Rework	7 i	Skid-tube	Crosstube		Water Jet	Engineering
Part No	D.			Scrap	 	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
NCR No				Use-as-is Work Order Update] Thern	Thermoforming Finishing Rec/Si Large Fab Composite			re/Packaging Supplier	Other
Root	T			Description of work order update	Initial	Ad	ction	Sign &		
Cause	Date	Step	Qty	or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling										
Operator										
Material				·						
Setup			,							•
Other						<u> </u>				
Process										
Supplier							•			
Training										
Unapproved	İ									

FAULT CATEGORY

Grain

Hardware

General

Bend

Folio

BOM/Route

Part Incorrect Broken/Damaged Inspection incomplete Cracks Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing Crushed/Crimped. Burrs Part Moved Maintenance Cuffs Contamination Mislabeled Positioned Wrong Countersink Heat Treat Other Power Loss/Surge Misread Inspection Strip in Tube Cut Too Short Offset Ripples in Bend Drill Holes Out of Calibration Drawing Torque Waves in Extrusion Out of Sequence Finish Turning Sequence

Outside Dimensions

Pressure/Forced

Weld

Temperature/Cure

Ovalized

Over/Under tolerance

Wave/Twist in Tube

Landing Gear

Bending

Centre Not Concentric to O/S

April-18-13 1:20:58 PM

Work Order ID: 100163

100163

Parent Item:

D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/18/13

Required Date: 5/02/13.

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A new issue DD 10.03.23 verified by:EC

IPP Rev:B as

per dwg revB DD 10.04.20 verified by:EC

IPP Rev:C as per dwg

revC DD 10.08.18 verified by:EC

IPP Rev D 12.03.27 per NCR12-

1239 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4086-200		Manufactured	No				Each	19.0000		1	 :	. 	
D4086-20 Placard, Max Load) 0								**		P		·- ·- · · · · · · · · · · · · · · · · ·
				Location	1	Loc	<u>Oty</u>	Loc Code					
				ST093			19		_	·	_		
					88611		5		_	\X_	- -		
		•			96251 98519		4		_		<u></u>		
D2530		Manufactured	No		96319	100	10 Each	15.0000	1 -	1	_		
D2530 Handle Weldment		wandiactured	110			100	Lacii	13.0000	**	I	80		
				Location	!	Loc	Qty	Loc Code					
				ST205			10						
					87086		10			1 X	_		
				ST255			5				_		
22525					86369		5				_		
02535		Manufactured	No			100	Each	50.0000	2	2			1
D2535									**	·	Sp)	3-5	-(+
				Location		Loc	<u>Oty</u>	Loc Code					
				ST011			50		_		_		
					96248		50		_	-2x	_		

			DQA:
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE	

		44							QA Closed:	Date:			
Work Orde					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS			
Part No. Scrap Use-as-is NCR No. Work Order Update							Skid-tube Crosstube Water Jet Engineering Machining Small Fab Prod. Eng. Coor. Quality Thermoforming Finishing Rec/Store/Packaging Other Large Fab Composite Supplier						
Root				Descri	ption of work order update	Initial	Ac	ction	Sign &				
Cause	Date	Step	Qty	1	or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector		
Doc/Data Equip/Tooling Operator													
Material				ļ									
Setup Other													
Process Supplier Training					e de la companya de l								
Unapproved	<u> </u>		<u> </u>	<u> </u>					<u> </u>		<u> </u>		
					F	AULT CATE	GORY						
Landin		•		<u>.</u>	General			 	1		7. /.		
	Bending	at Canaa	۔ جا ماندہ	O/5	Bend BOM/Route	Grain	aro		Ovalized Over/Under	tolerance	Pressure/Forced Temperature/Cure		
-	Centre No Cracks	or conce	ніліс іо	^{0/3} -	Broken/Damaged	—	tion Incomplete	<u> </u>	Part Incorre	·	Weld		
}	Crushed/	Crimped			Burrs	—	tions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled		
<u> </u>	Cuffs				Contamination	\vdash	enance		Part Moved		· ·		
`-	Heat Trea	at			Countersink	Mislab	eled .		Positioned V	Vrong			
	Inspection	n Strip in	Tube		Cut Too Short	Misrea	d	· _	Power Loss/	Surge	Other		
	Ripples in Bend Drill Holes				Offset								
	Torque Waves in Extrusion Drawing				Out of	Calibration	•						
	Turning Sequence Finish				Out of	Sequence		ť					
. [Wave/Twist in Tube Folio					Outsid	Outside Dimensions						

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-18-13 1:20:58 PM

Work Order ID: 1T00163

D4030-041

100163

Parent Item:

Parent Item Name: Long Basket Assembly (350)

D4030-041

Start Date: 4/18/13

Required Date: 5/02/13

Start Qty: 1.00

Required Qty: 1.00

D2537

Bushing

Manufactured No

100

Each

96.0000

**

**

**

Location Loc Qty Loc Code ST008 99011 24 ST011 72 92711 94713 40 98426 24 100 Each . 0.0000

Each

D3913-041

Long Basket Base Assemby, 350 D3914-041

D3914-041

Long Basket Lid Assembly (350) D3917-3

Washer

Manufactured

Manufactured

Manufactured

100

100

Each

90.0000 🚓

0.0000

**

Location Loc Qty ST072 92514 94136 94643 24 97710 60

Loc Code

			DQA:	Date:
ICR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE		
	•		QA Closed:	Date:

													The state of the s
Work Orde	ar:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIK OIGE						Rework	1	SI	kid-tube	Crosstube		Water Jet	Engineering
Part N	No.					Scrap	1 1		achining	Small Fab	Pro	d. Eng. Coor.	Quality
raitiv	•0					Use-as-is						Other	
NCR N	No.					Work Order Update	Large Fab Composite Supplier					-	
i i i i i i i i i i i i i i i i i i i							-		ت ت	· <u> </u>			
Root				, <i>i</i>	Descri	ption of work order update	Initi	al	Ac	tion	Sign &		
Cause	Di	ate	Step	Qty	(or Non-conformance	Chief	Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling											,		
Operator													
Material							1						
Setup '		-											
Other				,									
Process												}	
Supplier													
Training													
Unapproved							<u> </u>						
						F	AULT C	ATEG	ORY				
Landir	ng Gear					General					7	F	
	Ben	ding			L	Bend	Gra	ain			Ovalized	1	Pressure/Forced
	. Cen	tre No	t Concer	ntric to (o/s	BOM/Route	Har	rdware	9		Over/Under	F	Temperature/Cure
	Crac	cks				Broken/Damaged	Ins	pectio	n Incomplete		Part Incorre		Weld
	Crus	shed/C	Crimped.			Burrs	\vdash		ns Incomplete	/Unclear	Part Lost/M	_	Wrong Stock Pulled
] [Cuff	S				Contamination	\vdash	ainten		· <u> </u>	Part Moved		
	Heat Treat					Countersink	Mis	slabele	ed		Positioned \		
	Inspection Strip in Tube				Cut Too Short		sread			Power Loss/	'Surge	Other	
	Ripples in Bend			Drill Holes	\vdash	set					····		
	Torque Waves in Extrusion			Drawing	\vdash		libration						
	Turning Sequence			Finish	∐ Ou	t of Se	quence						
1 1	Waye/Twist in Tube					Teolio	Llou	tside [Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-18-13 1:20:58 PM

Work Order ID: 100163

D4030-041

100163 *D4030-041*

Parent Item:

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/18/13

Required Date: 5/02/13

Start Qty: 1.00

Required Qty: 1.00

D3953-3

Gas Spring Stud, Lid

Manufactured	N

No

100

Each

34.0000

**

B1604858P

Loc Qty	Loc Code	,		
1			•	
1				
21				
14				
7				
12				
12				
100 Eac	h 58.0000	2	2	
	7	**	\mathcal{A}	
	1 1 21 14 7 12	1 1 21 14 7 12 12 100 Each 58.0000	1 1 21 14 7 12	1

Spring Spacer

D3953-7

Location	<u>n</u>	Lo	c Oty	Loc Code
ST076	•		58	
	94669		34	
	99148		24	
		100	Each	65.0000

D3953-9

Gas Spring Washer

Manufactured

Manufactured

No

**

Location Loc Oty Loc Code ST076 94719 20 45

											DQA	: Dat	te:	
NCR:	es ,	/ No				WORK ORDER NON-O	O	VFORM	ANCE / UPDA	TE			-	
											QA Closed	: Dat	te:	
Work Orde	~					DISPOSITION				AGAINST DE	PARTMEN	T/PROCESS		
WORK Orde	er. —					Rework	1		Skid-tube	Crosstube	1	Water Jet		Engineering
Part N	Part No. Scrap												Quality	
						Use-as-is			noforming	Finishing	Rec/Sto	ore/Packaging		Other
NCR No.						Work Order Update]		Large Fab C	Composite]	Supplier		
											T c: 0	Т	_	
Root		_	_			ption of work order update	1	nitial	Action		Sign &	Vanification	_	OC Inchestor
Cause	\dashv	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descript	ion	Date	Verification	\Box	QC Inspector
Doc/Data														
Equip/Tooling							İ							
Operator	Щ													
Material					-								- !	,
Setup	Ш													
Other														
Process	Ш													
Supplier											1			
Training													ļ	
Unapproved											<u> </u>			
							AUL	T CATE	GORY					
Landi	ng Ge	ar				General		7		<u></u>	٦		_	1
	_	ending				Bend		Grain		<u> </u>	Ovalized		<u> </u>	Pressure/Forced
		Centre Not Concentric to O/S BOM/Route				⊣		Hardwa		ļ		er tolerance	L	Temperature/Cure
	Cracks Broken/Damaged						4 `	on Incomplete	<u> </u>	Part Incorr		\vdash	Weld	
	Crushed/Crimped. Burrs						Instruct	ions Incomplete/Unc	lear	Part Lost/N	•	L	Wrong Stock Pulled	
	∐ c	uffs				Contamination		Mainte	enance		Part Move	d		
	Н	eat Trea	t			Countersink	L	Mislabe	led		Positioned	Wrong	_	-
	Ir	Inspection Strip in Tube Cut Too Short				Cut Too Short		Misread Power Loss/Surge Other					Other	

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-18-13 1:20:58 PM

Work Order ID: 100163

100163

Parent Item:

D4030-041

D4030-041

Location

Location

ST077

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/18/13

Required Date: 5/02/13

Required Oty: 1.00

Start Qty: 1.00

**

D3953-17

D3953-19

Manufactured

No

100

Each

44

12

12

44.0000

Loc Code

Gas Spring Spacer

ST076 94578 97100 97696

Manufactured

20 100 Each

Loc Qty

16.0000

**

D3953-19 Gas Spring Bracket

D3953-21 Manufactured

D3953-21

92819 97691

16 4 12 100 Each

Loc Qty

10

10

6

Loc Qty

18.0000

Loc Code

Gas Spring Bracket

Manufactured

Location Loc Qty ST075 12 97714 12 ST077 6 94146 6 100 Each Loc Code

**

**

Spring (Basket Lid)

▶ D3969-3

Location ST262 91844 ST272

97050

Loc Code

16.0000

April-18-13 1:20:58 PM

Shop Packet Print

Page 4

											DQA:	Date	e:
NCR: Y	es/	/ No				WORK ORDER NON-	cor	NFORM	MANCE / UP	DATE	QA Closed:	Date	e:
						DISPOSITION							
Work Order:						Rework Scrap	Skid-tube Crosstube Machining Small Fab			i	Water Jet d. Eng. Coor.	Engineering Quality	
NCR N	NCR No.				·	Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Store/Packagin Supplie		Other
Root					Descri	ption of work order update	T 1	Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling	_												
Operator													
Material	Ц												
Setup	\dashv				,								
Other													
Process	\dashv			<u> </u>									
Supplier	-												
Training													
Unapproved				<u> </u>	<u></u>		1	T CATE	CORY		<u> </u>	<u> </u>	
Landi						F General	AUL	LICATE	GURT				
Landii		ear Bending				Bend	Γ	Grain			Ovalized	Γ	Pressure/Forced
	-	Centre No	ot Conco	ntric to		BOM/Route		Hardwa	re.		Over/Under	tolerance	Temperature/Cure
		Cracks	or concei	ntric to	^{0/3} -	Broken/Damaged	\vdash	4	ion Incomplete	<u> </u>	Part Incorre	F	Weld
	\vdash	Cracks Crushed/(Crimped		<u> </u>	Burrs	\vdash	4 `	ions Incomplete/	Unclear	Part Lost/M	F	Wrong Stock Pulled
	_	Cuffs Cuffs	стпрей.		<u> </u>	Contamination	-	Mainte	·	- Citereal	Part Moved		
		Curis Heat Trea	ıt.		-	Countersink	\vdash	Mislabe		 	Positioned \	Vrong	
		Inspection		Tube	-	Cut Too Short	-	Misread		-	Power Loss/		Other
	_	Ripples in	-	TUDE	<u> </u>	Drill Holes	-	Offset	- ,	L	1 2 5 . 2000/		1
		Torque W		xtrusio	n 📙	Drawing		-∤	Calibration				

Out of Sequence
Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-18-13 1:20:58 PM

Work Order ID: 100163 *100163* Parent Item: D4030-041 *D4030-041* Parent Item Name: Long Basket Assembly (350) Required Date: 5/02/13 **Start Date: 4/18/13** Start Qty: 1.00 Required Qty: 1.00 AN3-14A Purchased No 100 Each 87.0000 *AN3-14A* ** Bolt **Location** Loc Oty Loc Code \$T512 87 123759 87 AN3-16A Purchased No 100 Each 102.0000 2 *AN3-16A* ** Bolt Location Loc Qty Loc Code GA 47 117441 47 ST352 55 122407 8 123900 47 AN5-17A Purchased No 100 Each 152.0000 *AN5-17A* ** Location Loc Qty Loc Code GA 36 117872 36 ST337 116 124215 50 124805 66 AN4-12 Purchased No 100 71.0000 Each 3 ** Location Loc Code Loc Oty ST356 71

21

50

122800

124805

37

											DC)A:_	Date	::		
NCR:	Yes	/ No				WORK ORDER NON-C		NFORM	AANCE / UPI	DATE	OA Class	~ d.	Date			
								<u></u>	6.00		QA Close	ea:	Date			
Work Orde	o.r.					DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Work Orde	-					Rework		Water Jet			7 Eng	ineering				
Part No.						Scrap		r	Skid-tube Machining noforming	Crosstube Small Fab Finishing	Prod. Eng. Coor.				Quality Other	
NCR No.						Use-as-is Work Order Update		Large Fab	Composite							
Root					Descri	ption of work order update	Γi	Initial	Act	tion	Sign &	į.				
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Desc	ription	Date		Verification	Q	C Inspector	
Doc/Data																
Equip/Tooling																
Operator									•		İ	1				
Material			-													
Setup	Ш							'				İ				
Other	Ш															
Process													•			
Supplier	Ш												•	Ī		
Training										•						
Unapproved																
							AUL	T CATE	GORY							
Landi	ng G	iear			_	General		7		_			_	_	-	
	-	Bending			ļ	Bend		Grain			Ovalized		<u> </u>		ure/Forced	
		Centre No	ot Concer	ntric to	o/s	BOM/Route	_	Hardwa		-	⊣		olerance		erature/Cure	
		Cracks				Broken/Damaged	_	- 1 '	on Incomplete	<u> </u> -	Part Inco		}-	Weld		
	\vdash	Crushed/	Crimped.			Burrs	<u></u>	4	ions Incomplete/	Unclear	Part Lost		sing	Wron	g Stock Pulled	
	—	Cuffs				Contamination	\vdash	Mainte		<u> </u>	Part Mov					
		Heat Trea			<u> </u>	Countersink	_	Mislabe		<u> </u> _	Position					
		Inspection	n Strip in	Tube		Cut Too Short		Misread	i	L	Power Lo	oss/S	urge	Other	<u> </u>	
	Ripples in Bend Drill Holes						Offset									

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-18-13 1:20:58 PM

Work Order ID: 100163

Parent Item:

D4030-041

Parent Item Name: Long Basket Assembly (350)

100163

D4030-041

Location

Location

ST342

ST506

123900

124291

ST342

Start Date: 4/18/13

Required Date: 5/02/13

Start Qty: 1.00

Required Qty: 1.00

AN310-4

AN310-4

Purchased

No

100

Each

72.0000

Loc Code

**

AN310C4

AN310C4

Purchased

No

122800 124221

100

Loc Qty

Loc Qty

86

2

4354

974

3380

72

2

70 Each

86.0000

Loc Code

**

MS21042L3

Purchased

No

123831 124221 100

84 Each

4,739.000 **

MS21042L3

Nut

Location Loc Qty Loc Code FP001 3 122141 3 GA 114 122452 114 ST314 268 117885 32 119017 55 119075 138 123265 43

										DQA:	Date	·			
NCR: Y	es / No				WORK ORDER NON-C	CON	IFOR!	MANCE / UP	DATE	QA Closed:	Date	:			
				· · · · · · · · · · · · · · · · · · ·	DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Work Orde	er:				Rework		Skid-tube Crosstube				Water Jet	Engineering			
Part N	lo				Scrap			Machining	Small Fab	-	d. Eng. Coor.	Quality			
****					Use-as-is			noforming	Finishing	Rec/Sto	re/Packaging	Other			
NCR N	10.				Work Order Update]		Large Fab	Composite	1	Supplier				
Root					iption of work order update	1	nitial		tion	Sign &					
Cause	Date	Step	Qty		or Non-conformance	Chi	ief Eng	Desc	cription	Date	Verification	QC Inspector			
Doc/Data															
Equip/Tooling											,				
Operator															
Material -												1			
Setup															
Other															
Process Supplier															
Training	_										·				
Unapproved											1				
onapproved	<u></u>	1	<u> </u>		F	AUL	T CATE	GORY							
Landii	ng Gear			· · · · · · · · · · · · · · · · · · ·	General										
	Bending				Bend		Grain			Ovalized		Pressure/Forced			
	Centre N	ot Conce	ntric to (o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure			
	Cracks				Broken/Damaged		Inspecti	on Incomplete	<u>L</u>	Part Incorre	ct	Weld			
	Crushed/	/Crimped			Burrs		Instruct	ions Incomplete/	/Unclear	Part Lost/M	issing	Wrong Stock Pulled			
	Cuffs				Contamination		Mainte	enance	·	Part Moved					
	Heat Tre	at			Countersink .		Mislabe			Positioned \		-			
	Inspection	n Strip in	Tube		Cut Too Short	Ш	Misread	t		Power Loss/	'Surge	Other			
	Ripples in	n Bend			Drill Holes	-	Offset			·					
	Torque V	Vaves in l	Extrusion	n	Drawing		Out of 0	Calibration							

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-18-13 1:20:58 PM

Work Order ID: 100163

Parent Item:

D4030-041

Parent Item Name: Long Basket Assembly (350)

100163 *D4030-041*

Location

Location

GA

ST323

Start Date: 4/18/13

Required Date: 5/02/13

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

MS21042L5

Nut

MS24665-151

MS24665-151 Cotter Pin

Purchased

Purchased

No

No

ST506 123900

100

100

337 . Each

Loc Qty

28

28

337

Loc Qty

Each

137.0000

Loc Code

Loc Code

337.0000

**

**

MS24665-300

Purchased

No

122802 124859

17566

109 59 50 100 Each

219.0000 **

MS24665-300

Location Loc Qty GA 37 118234 37 ST299 182 124555 182

Loc Code

NCR: Y	/es	/ No				WORK ORDER NON-O	CONF	ORN	MANCE / UPDATE	QA Closed:	Date:				
Work Orde	or.					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No						Rework Scrap Use-as-is Work Order Update	Machining Small Thermoforming Finis			Pro Rec/Sto	Engineering Quality Other				
Root		·			Descri	ption of work order update	Initi	al	Action ,	Sign &					
Cause		Date_	Step	Qty	(or Non-conformance	Chief	Eng	Description	Date	Verification	QC Inspector			
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved															
							AULT C	ATE	GORY						
Landing Gear Bending Centre Not Concentric to O/S					0/5	Bend BOM/Route	·				tolerance	Pressure/Forced Temperature/Cure			

Inspection Incomplete

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Broken/Damaged

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Burrs

DQA:

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Date:

Weld

Other

Wrong Stock Pulled

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

April-18-13 1:20:58 PM

Work Order ID: 100163

Parent Item:

D4030-041

Parent Item Name: Long Basket Assembly (350)

100163 *D4030-041*

Start Date: 4/18/13

Required Date: 5/02/13

Start Qty: 1.00

**

Required Qty: 1.00

NAS1149F0432P

Purchased

Purchased

Purchased

No

No

No

100

Each

1,878.000

6

NAS1149F0432P

Washer

Location	Loc	<u>Oty</u>	Loc Code
ST295		1878	
122151		2	
123522		4	
123900		172	
124580		400	
124859		300	
125268		1000	
	100	Each	728 0000

**

NAS1149F0563P

NAS1149F0563P Washer

NAS1149F0332P

Location	Loc Qty	
ST295	728	:
121350	728	;
	100 E	Each

**

Loc Code

8,690.000

NAS1149F0332P WASHER

Location Loc Qty Loc Code $\mathsf{G}\mathsf{A}$ 182 122063 182 ST294 158 122063 158 ST295 3 123352 3 st510 8347

8347

123900

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-C	O	QA Closed:					
				u. 2004 2		Q						Date:	
Work Ord	0.51					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Work Ord	er. -			·		Rework		Skid-tube Crosstube			1	Water Jet	Engineering
Part	Nο					Scrap		l .	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
, are	-		ME.			Use-as-is		Thermoforming Finishing			Rec/Stor	e/Packaging	Other
NCR	NCR No.				Work Order Update			Large Fab	Composite]	Supplier		
	•												· · · · · · · · · · · · · · · · · · ·
Root					Descri	ption of work order update	l	nitial		ction	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data	Щ												
Equip/Tooling	Ц												
Operator	Ш												
Material	Ш												
Setup	\sqcup												
Other							1						
Process	Н	•								•			
Supplier	Н												
Training	Н												
Unapproved		-,	<u> </u>				<u> </u>	T CATE	GORV		<u> </u>	<u> </u>	
Land		2025			····	General	AUL	CAIL	<u> </u>				
Lanu		Bending			Г	Bend	Г	Grain			Ovalized	[Pressure/Forced
	-	Centre No	ot Conce	ntric to ()/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	-	Cracks	or conce		""	Broken/Damaged	\vdash	4	on Incomplete		Part Incorre	—	Weld
	-	Crushed/	Crimped			Burrs		4 `	ions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	\vdash	Cuffs				Contamination		Mainte			Part Moved	<u> </u>	_
	-	Heat Trea	at			Countersink		Mislabe	eled		Positioned \	Vrong	
	-	Inspectio		Tube		Cut Too Short		Misread	i		Power Loss/	'Surge	Other
	\vdash	Ripples ir				Drill Holes		Offset					
						Drawing		Out of 0	Calibration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-18-13 1:20:58 PM

Work Order ID: 100163

Parent Item: D4030-041

NAS1149C0432R

NAS1149C0432R

Washer

Parent Item Name: Long Basket Assembly (350)

Purchased

No

D4030-041

Start Date: 4/18/13

Required Date: 5/02/13

Required Qty: 1.00

Start Qty: 1.00 1,686.000

**

Location	Loc Qty	Loc Code	
ST292	1686		
119124	6		
122441	1680		- 9x

Each

100

											DQA:	Date	е.	
NCR:	⁄es	/ No				WORK ORDER NON-O	01	QA Closed:	Date	۵٠ -				
									A.C.A.I.		PARTMENT	 	· ·	
Work Orde	er:					DISPOSITION		AGAI	N21 DE	PAKTIVIENT	PROCESS			
Part No.						Rework Scrap	l .	Skid-tube Crosst Machining Small	-	Water Jet Prod. Eng. Coor.			Engineering Quality	
l	NCR No.					·				ning site	Rec/Sto	re/Packaging Supplier		Other
Root			1		Descri	ption of work order update		Initial	Action		Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Description		Date	Verification	<u> </u>	QC Inspector
Doc/Data														
Equip/Tooling														
Operator							Ì							
Material												1		
Setup			1											
Other]		
Process														
Supplier														
Training														
Unapproved			<u> </u>				<u> </u>				<u></u>	<u> </u>		
						· · · · · · · · · · · · · · · · · · ·	AUI	LT CATE	GORY					·
Landi					_	General	_	7			1	Γ		l- <i>(</i> - ,
	-	Bending				Bend		Grain		<u> </u>	Ovalized			Pressure/Forced
		Centre No	ot Concer	ntric to	O/S	BOM/Route		Hardwa		<u> </u>	Over/Under	}		Temperature/Cure
		Cracks				Broken/Damaged	_	⊣	on Incomplete	<u> </u>	Part Incorre			Weld
	-	Crushed/	Crimped.			Burrs	\vdash	-	ions Incomplete/Unclear	<u> </u>	Part Lost/M			Wrong Stock Pulled
	Ш	Cuffs				Contamination	_	Mainte			Part Moved			
		Heat Trea	it			Countersink		Mislabe		<u> </u>	Positioned \	· · · · · · · · · · · · · · · · · · ·		1
		Inspection Strip in Tube Cut Too Short					L	Misread	d	<u> </u>	Power Loss/	'Surge [Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Drill Holes

Drawing

Finish Folio

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G





